

Work Order ID: 92947-2

November-12-12 1:35:16 PM

SPLIT-2
change high part to RD-4367

92947

Page 1

Item ID: D4634-3

Revision ID:

Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012 Start Qty: 2.00

Required Date: 12/12/2012 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

ML5

Date: 12-11-12 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Draw Nbr	Revision Nbr	Up/	Tool ID	Tool #	Plan	Accept	Reject	Reject	sp.
		k a Hour			Code	Qty	Qty	Number	amp

Draw Nbr

Revision Nbr

D4634

A B Wh. 12/02/20

100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x2

DAS 07 2-09

12/12/04

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 7:00 pm 12/12/03

Time OUT: 7:00 am 12/12/04

x2

DAS 27 2-04

12/12/04

Work Order ID 92947

November-12-12 1:35:16 PM

92947

Page 2

Item ID: D4634-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Lot ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4634-3 and Folio FTA145

Dwg. Rev. A

Folio Rev. A

Visually inspect for proper formation and texture

12

12/12/04

130

0.00

130

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

Y1

13/03/12

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

X1

13/03/12

Work Order ID 92947

92947

November-12-12 1:35:16 PM

Item ID: D4634-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Net Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

LOCATION

MED TAB

JB

13/03/25

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

already tested
used
w/p. 100577

13/3/27

mk
3327

Picklist Print

November-12-12 1:35:20 PM

Page 1

Work Order ID: 92947

92947

Parent Item: D4634-3

D4634-3

Parent Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028.362	14.97	33.26667			

MKYD6185S 080-P3-62015

**

185 KYDEX .080"

Loc

Est

Loc Code

therm

1028.362377

116576

14.148377

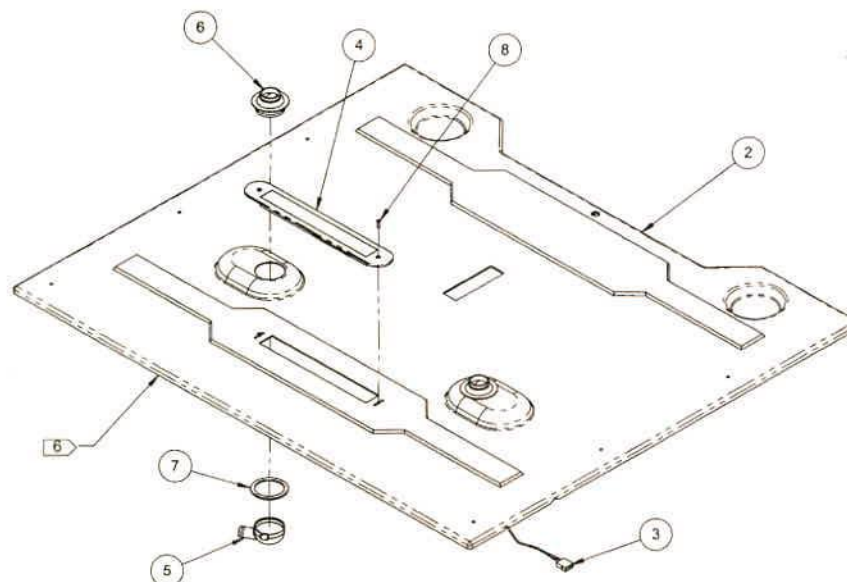
121755

1014.214

33.27 sq ft

DL
12/12/10

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
4	1	D4638-1	LED LIGHT
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3	MOUNTING NUT
8	2	MS24694-S5	SCREW
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)



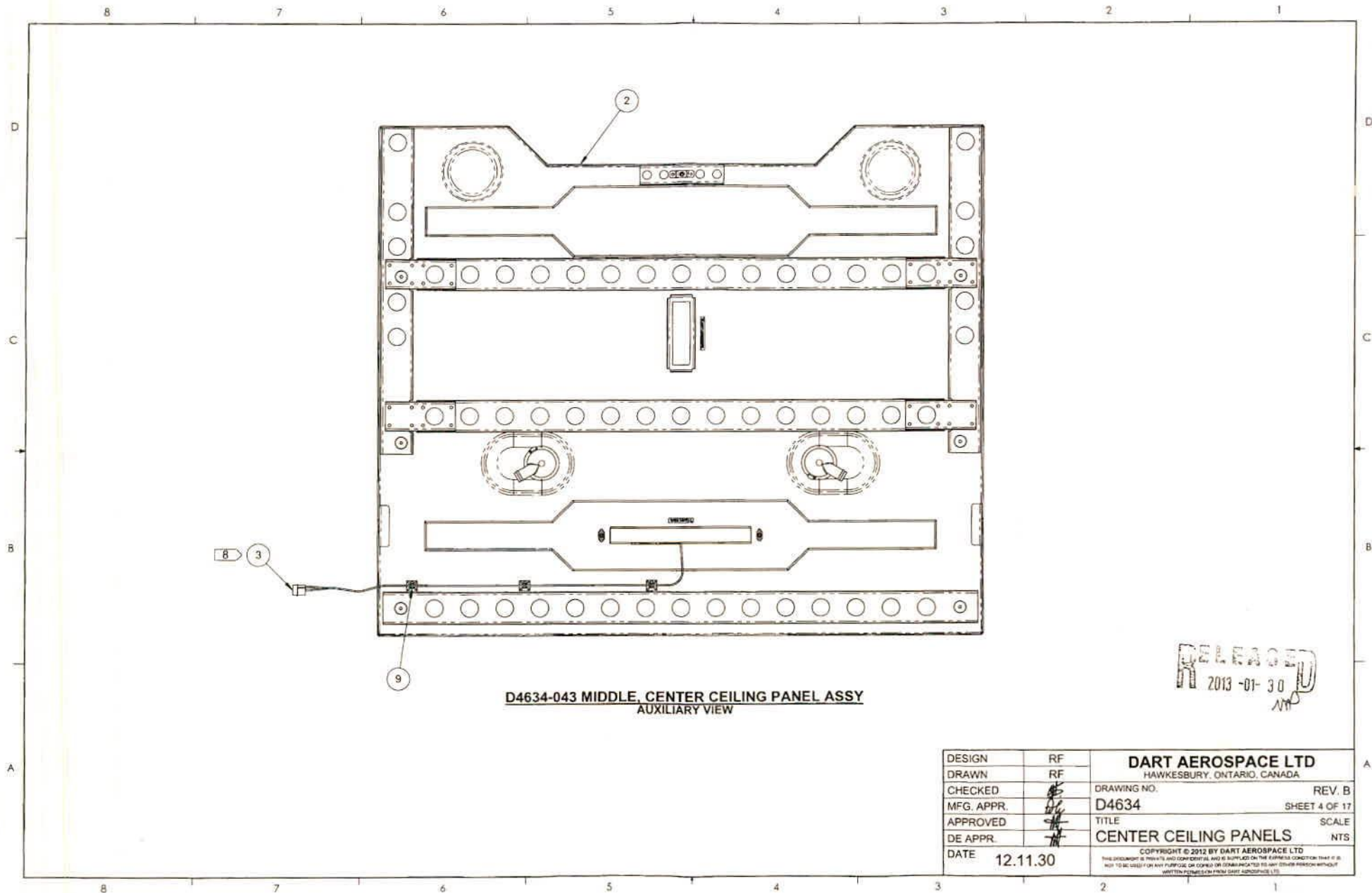
D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

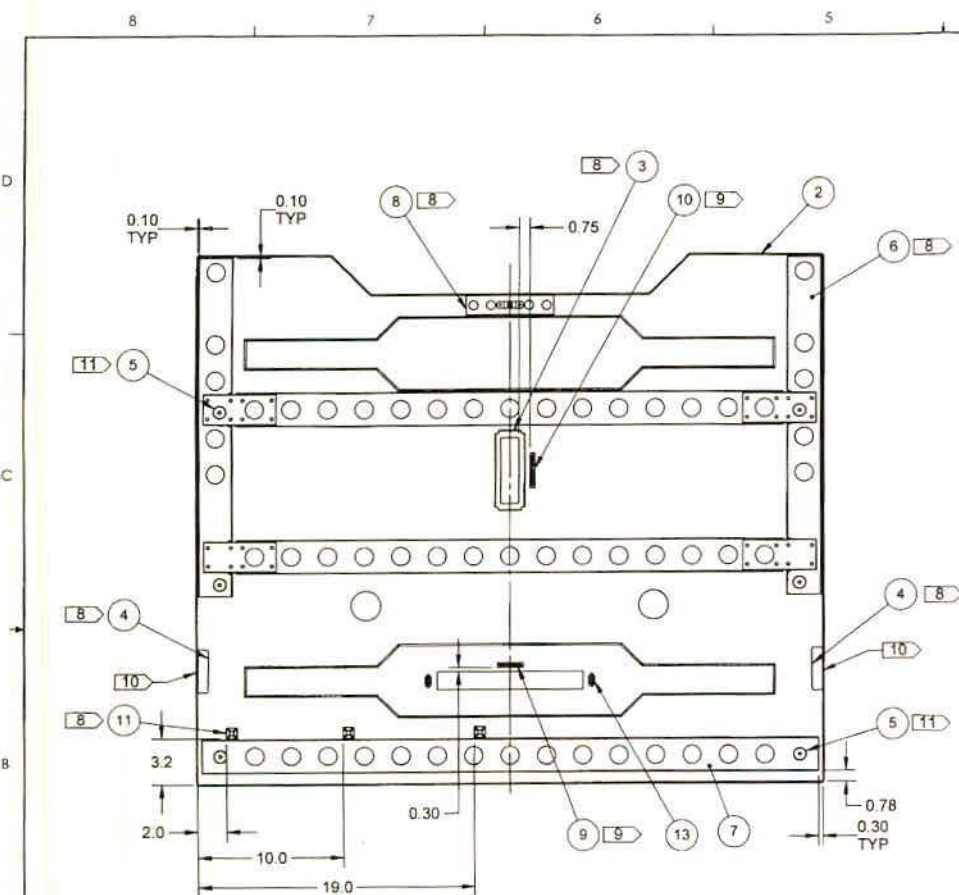
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2013-01-30

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MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 3 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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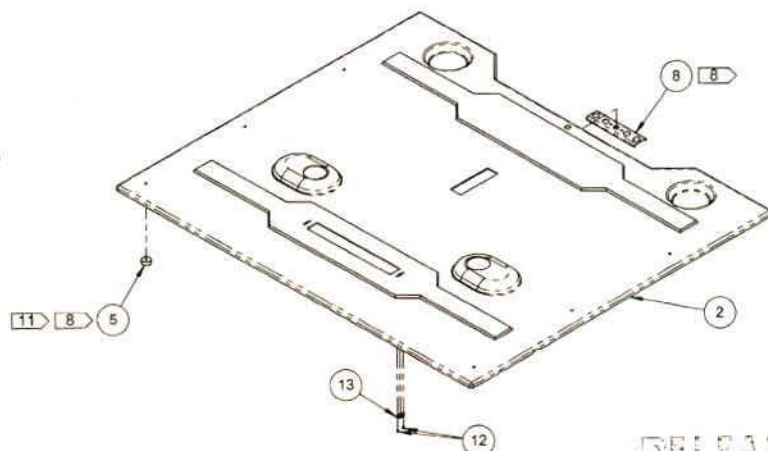


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ITEM NO.	QTY. -143	PART NUMBER	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	1	D4647-1	DOUBLER
4	2	D4647-3	ANGLE
5	6	D4664-5	SPACER
6	1	D4694-043	MIDDLE CHANNEL ASSEMBLY
7	1	D4694-7	MIDDLE CHANNEL
8	1	D4712-041	BRACKET ASSEMBLY
9	1	D4732-21	LABEL
10	1	D4732-25	LABEL
11	3	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-3	RIVET
13	2	MS21059L3	ANCHOR NUT



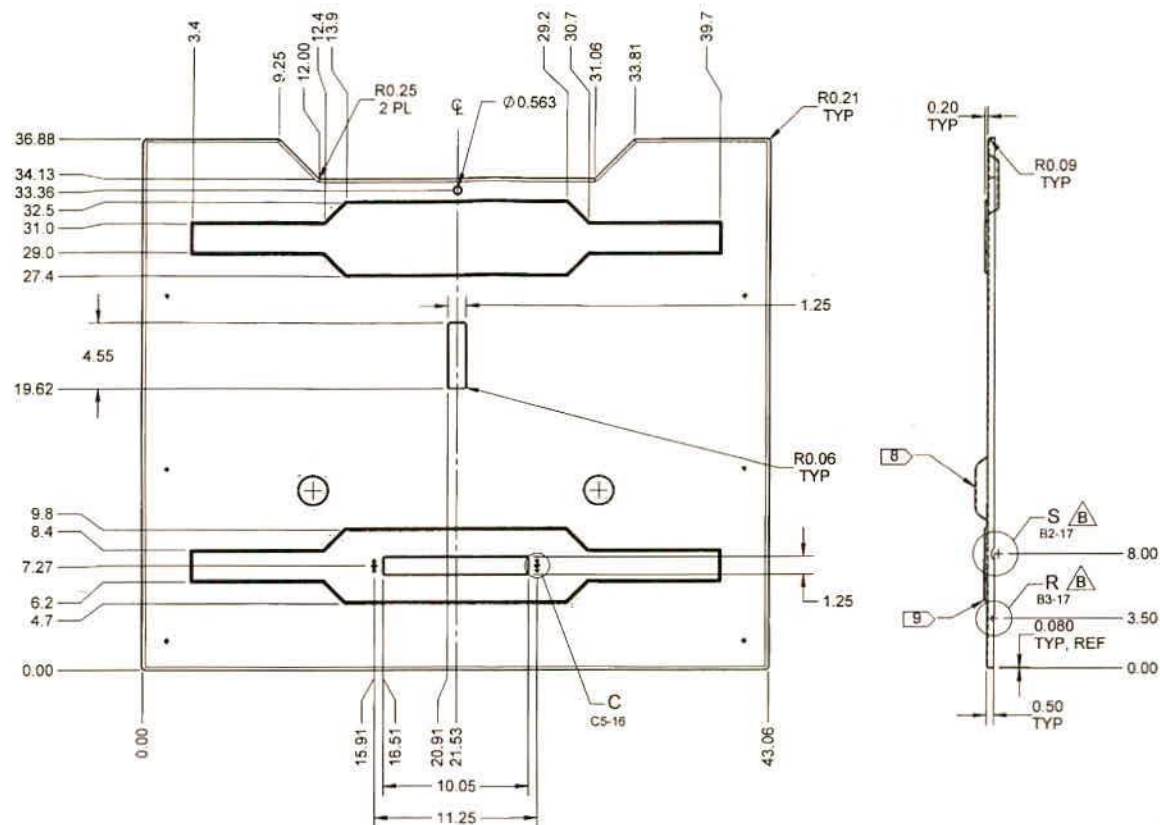
D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4647-1, D4647-3, D4664-5, D4694-043/-7, D4712-041 & MPNY-750S-9-C WAIT FOR 24 HOURS TO CURE. LOCATE D4664-5 IN LINE WITH $\phi 0.204$ HOLES. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-3 MIDDLE CENTER PANEL
- 11) TRANSFER $\phi 0.204$ (#6 DRILL) FROM D4634-3 TO D4694-043/-7 PRIOR TO BONDING D4664-5

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NOTES:

1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.31 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-3 PER TOOL DT9837

11) THERMOFORM PER QSI 022 USING DT9845 TOOL

MIN. THICKNESS AFTER FORMING:

EDGES = 0.060

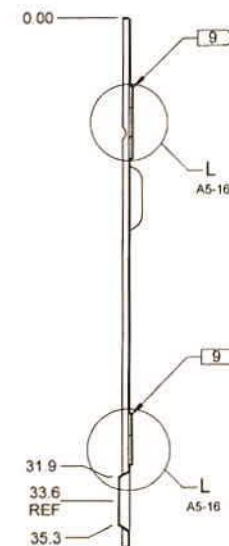
ELSEWHERE = 0.070

B 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

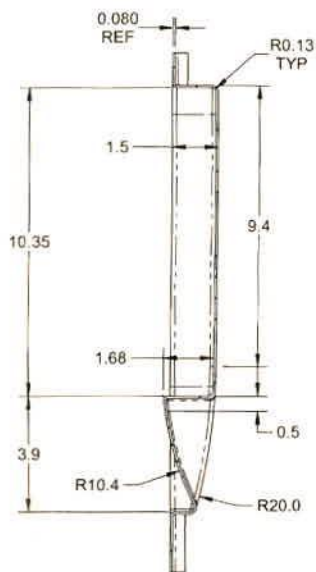
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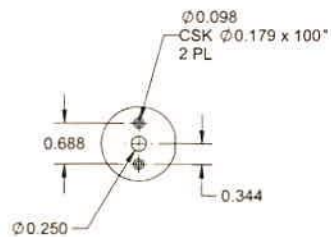


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2013-01-30
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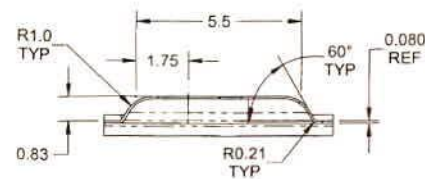
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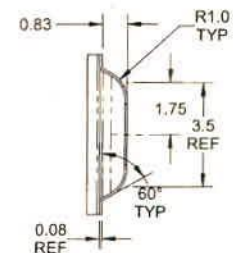
SECTION G-G C5-11
SCALE 4X



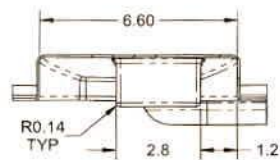
DETAIL C B7-10
SCALE 4X B4-12
B4-14



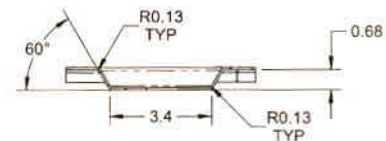
SECTION D-D B6-11
SCALE 2X C4-13
C4-16



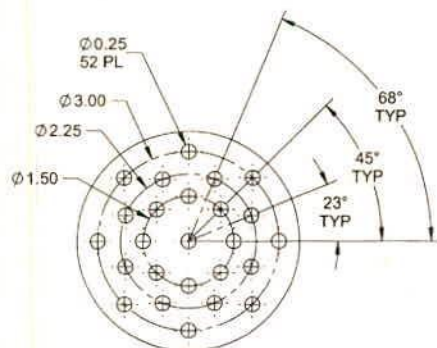
SECTION E-E B5-11
SCALE 4X C4-13
C5-15



SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X



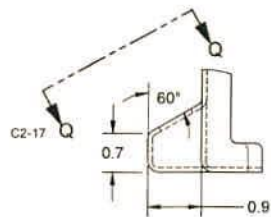
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SCALE 4X
2 PL



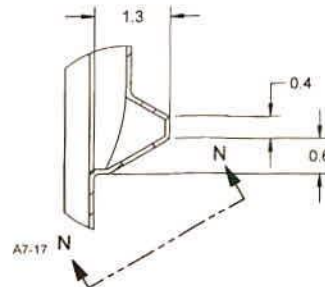
DETAIL L B2-13
SCALE 4X C2-13
TYP B2-14
C2-14

2013-01-30

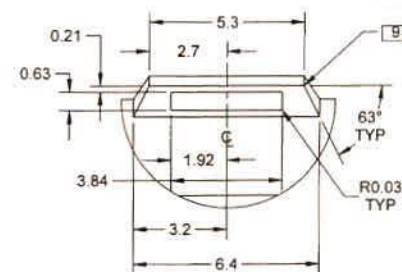
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DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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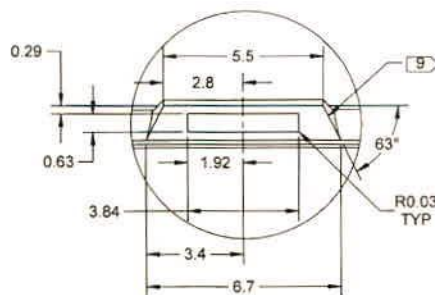
DETAIL P B3-14
SCALE 2X



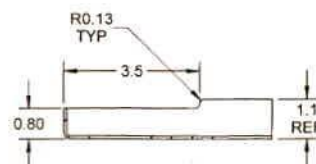
DETAIL M C3-10
SCALE 2X



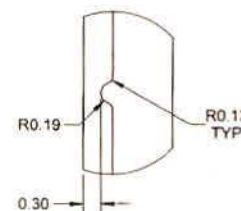
DETAIL Q B4-15
SCALE 0.5X D8-17



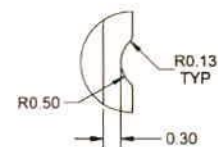
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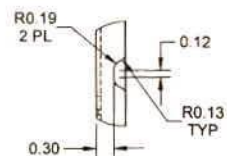
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

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DART AEROSPACE LTD		Work Order: 92947
Description: 139 MIDDLE CENTER CEILING PANEL		Part Number: D4634-3.
Inspection Dwg: 4634	Rev: 3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: JB	Date: 13/03/19
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.88	36.875	36.875			TH-05	
43.06		43.06			TH-05	
33.36		33.36			TH-05	
19.62		19.625			TH-05	
4.55		4.50			TH-05	
1.25		1.22			TH-05	
7.27		7.28			TH-05	
10.05		10.00			TH-05	
1.25		1.23			TH-09	
11.25		11.27			TH-09	
.50		.537				

Measured by: JB	Date: 13/03/19
Audited by: S 13/03/19	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

DART AEROSPACE LTD		Work Order: 92947
Description: 139 Middle Center Ceiling Panel		Part Number: D4634-3
Inspection Dwg: 4634	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB	Date: 13/03/19
-----------------	----------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50		3.50			TH-05	
8.00		8.00			TH-05	
1.66		1.65			DL-02	
2.02		1.97			DL-02	
12.00		12.00			TH-05	
24.00		24.00			TH-05	
12.5		12.875			TH-05	
11.7		11.8			TH-05	
39.75		39.70			TH-05	
2.07		2.065			DL-02	
.060		.069				
.070		.075				

Measured by: BB	Date: 13/03/19
Audited by: 6 13/03/19	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

AD 10 03/19